

Preparing a controlled content molten gray
iron base metal



Transferring the controlled content molten
gray iron base metal to a pouring ladle



Alloying the controlled content gray iron base
metal in the pouring ladle with tin to a total
tin content of about 0.05% to about 0.10%



Inoculating the tin-alloyed controlled content
gray iron base metal with an inoculant to a
silicon-addition of about 0.10% to about
0.12%



Casting parts as soon as possible after said
inoculation

FIG. 1